



- $\alpha$  - Rake angle
- $\phi$  - Shear plane angle
- $\gamma$  - Clearance angle
- $t_0$  - Undeformed chip thickness
- $t_c$  - Deformed chip thickness
- $v_c$  - Cutting velocity

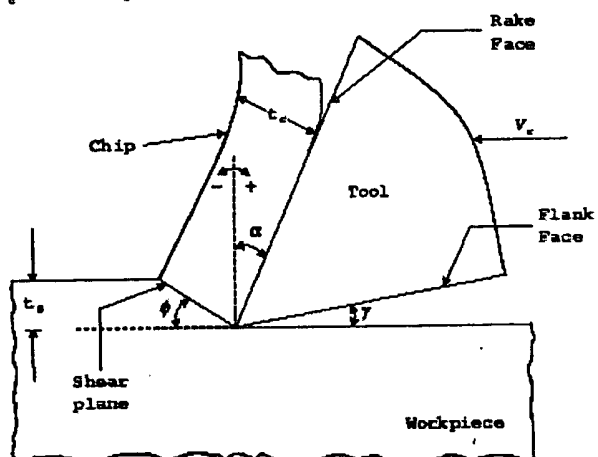


Figure 1

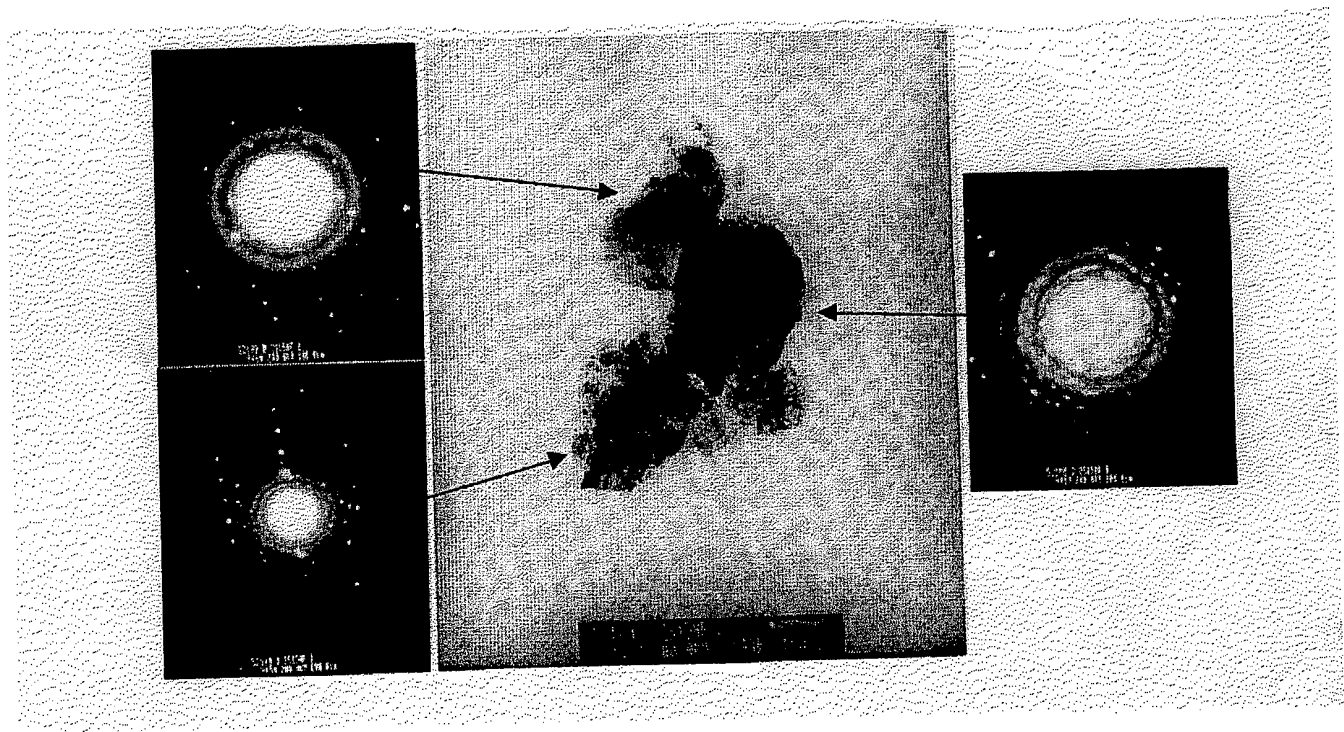


Figure 2

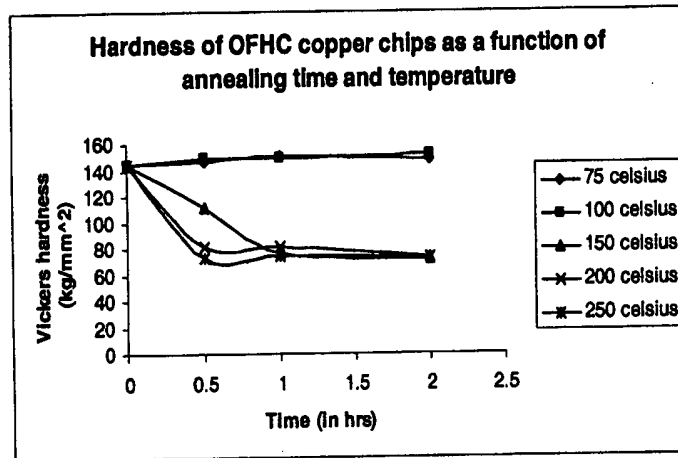
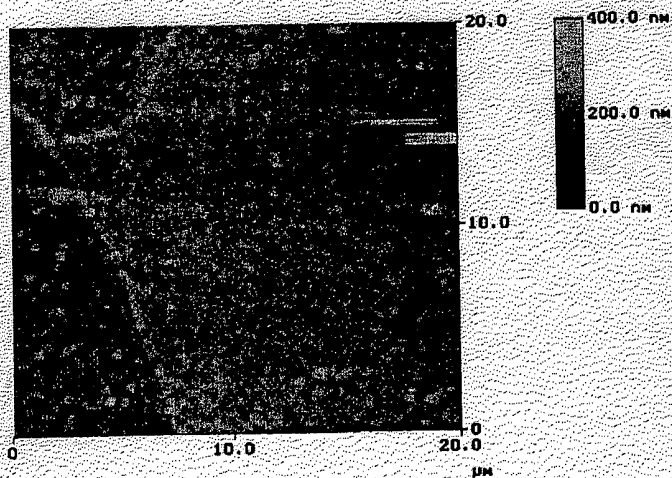
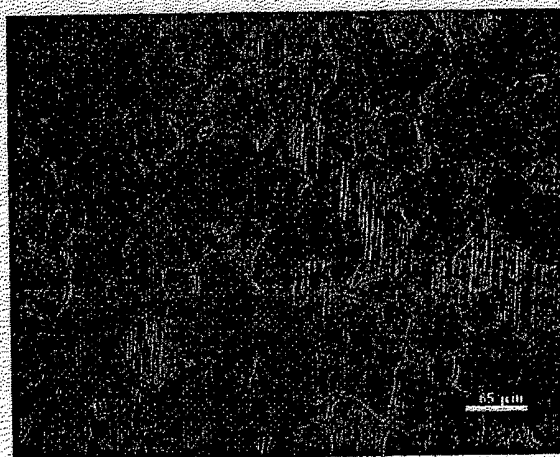


Figure 3

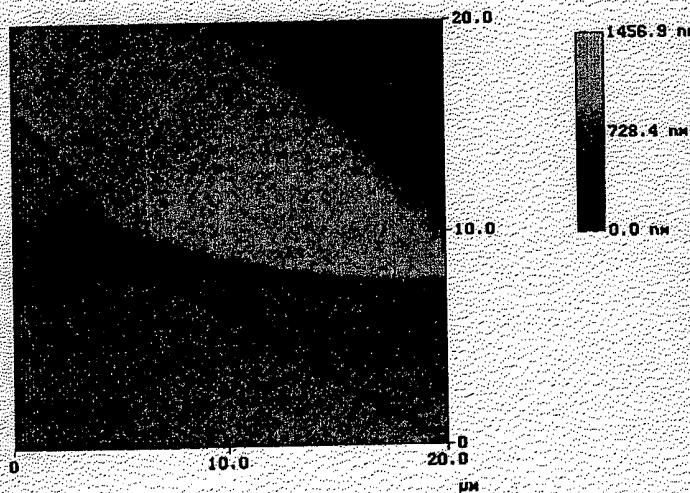


AFM

Figure 4

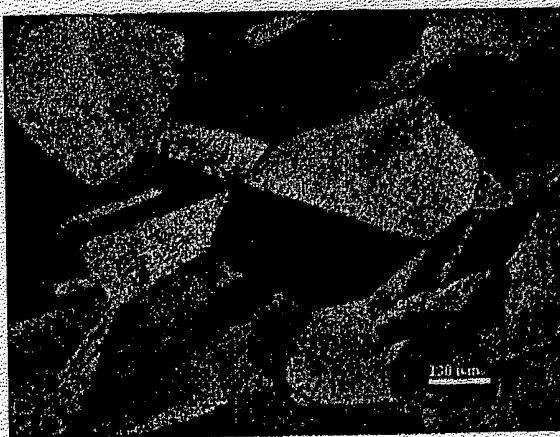


Optical Microscope

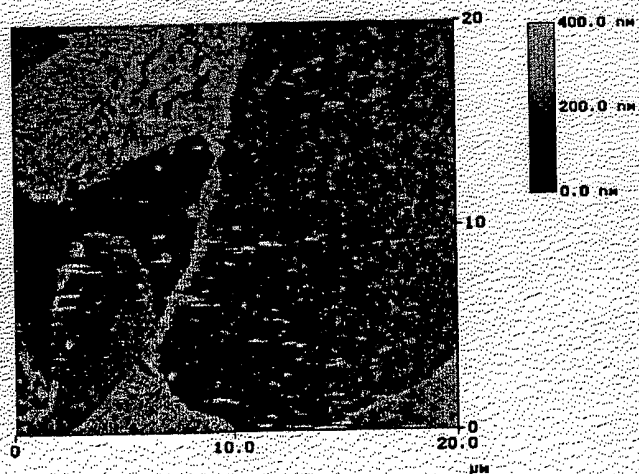


AFM

Figure 5

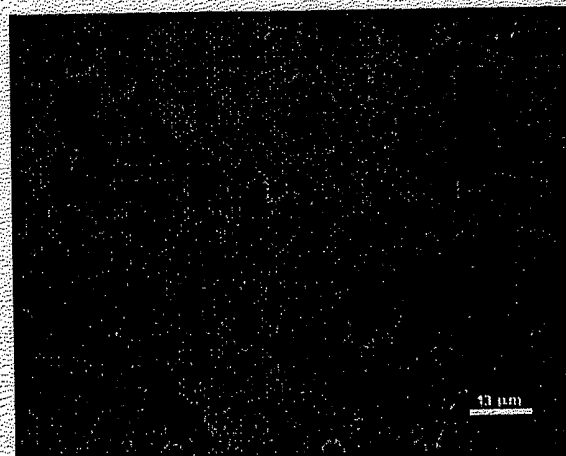


Optical Microscope

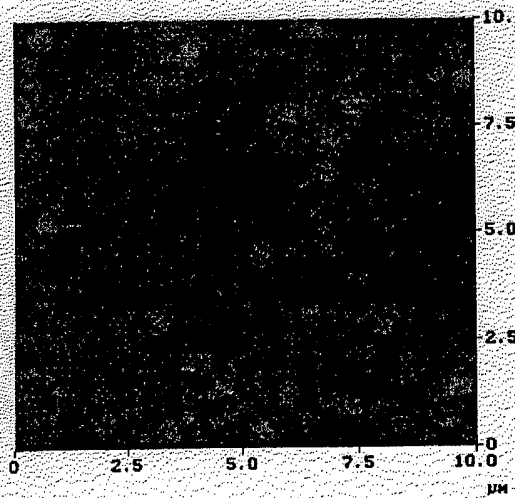


AFM

Figure 6

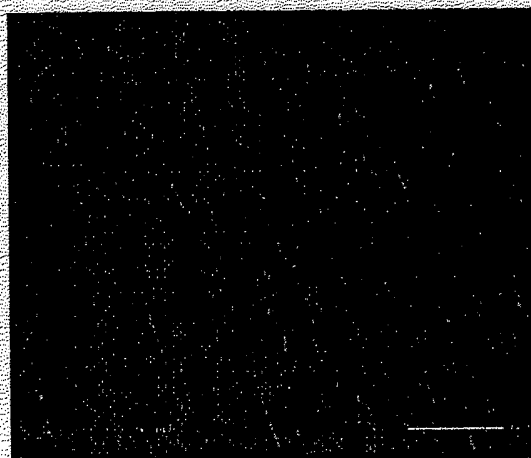


Optical Microscope

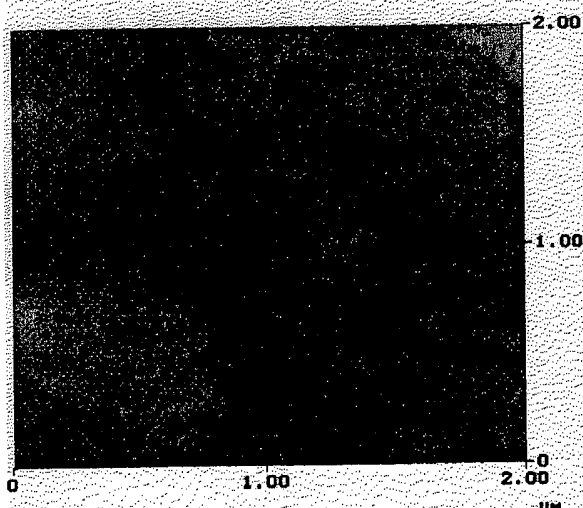


AFM

Figure 7

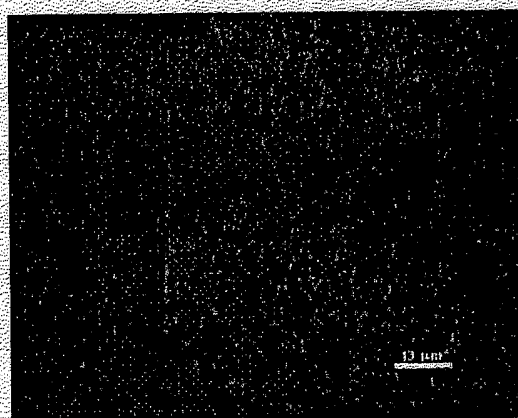


SEM

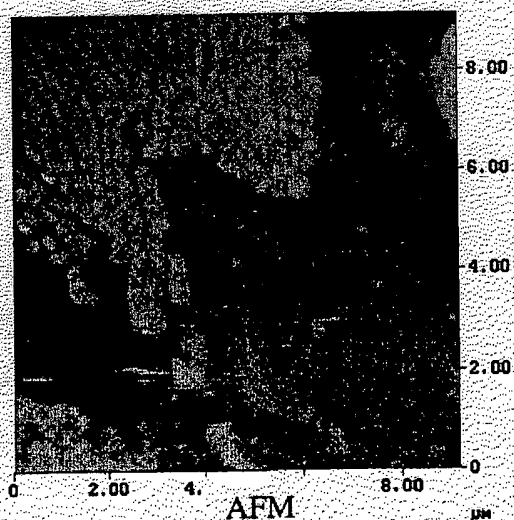


AFM

Figure 8

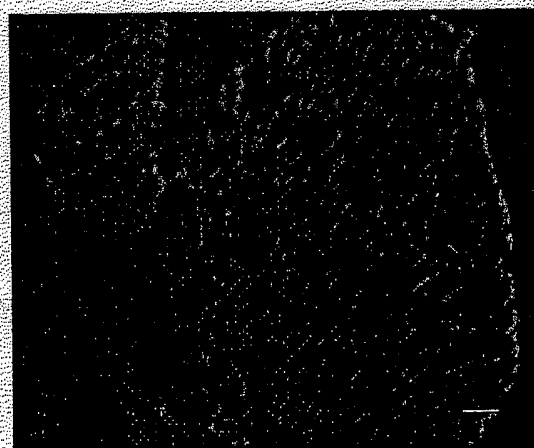


Optical Microscope

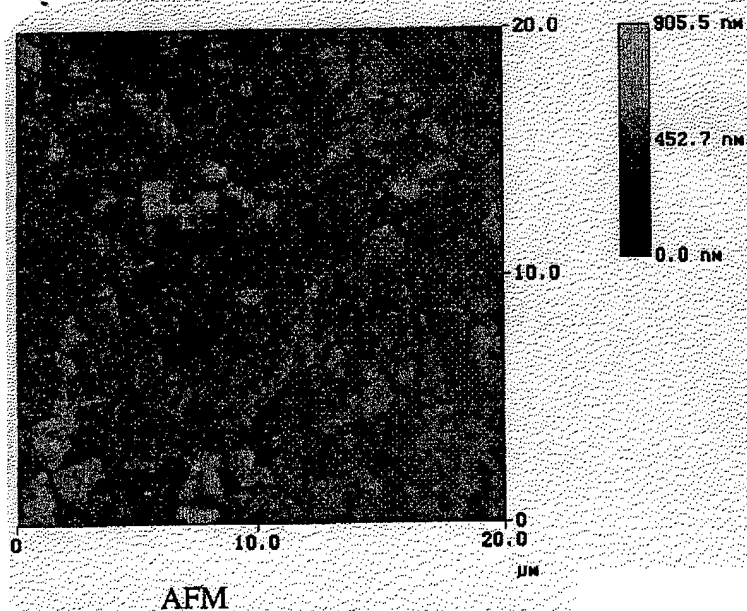


AFM

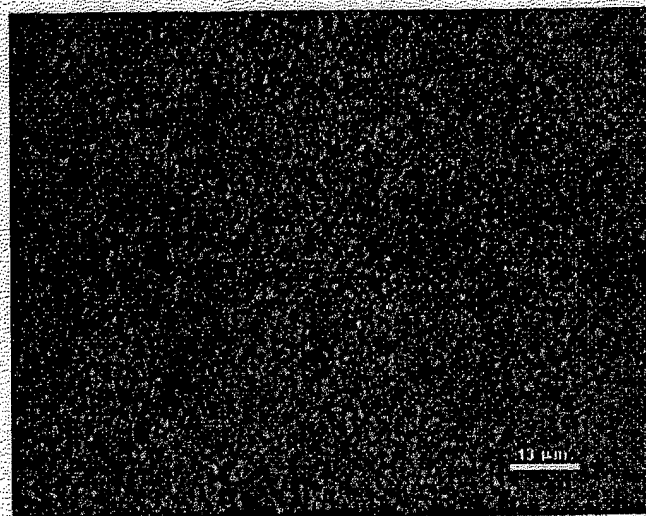
Figure 9



SEM

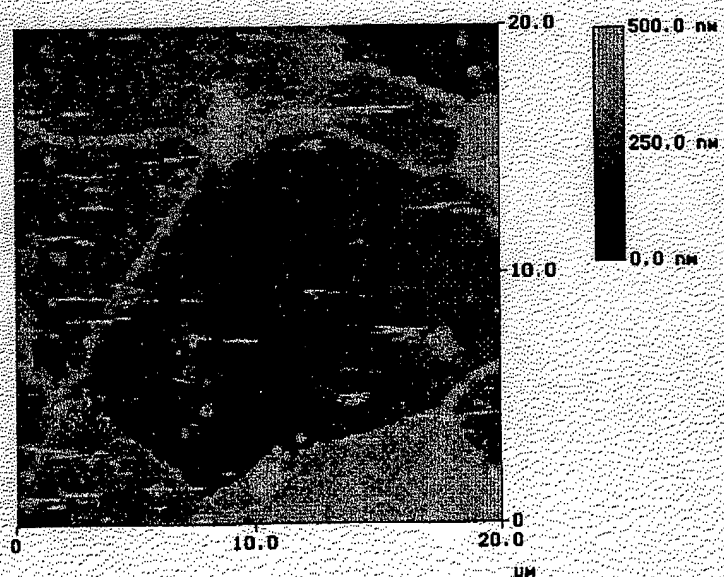


AFM

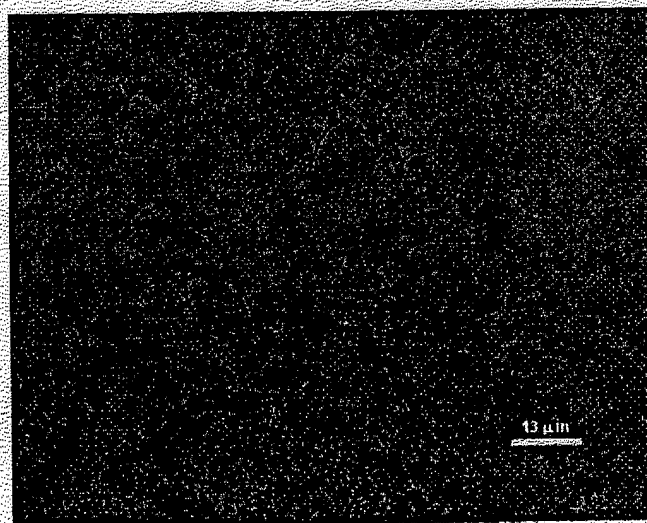


Optical Microscope

Figure 10



AFM



Optical Microscope

Figure 11